Work Order ID 64563

Wednesday, December 08, 2010 10:26:43 A



Page 1

Item ID: D3286-1 Accept Setup Start Pevision ID: Stop Doubler **Item Name: Start Date:** 12/8/2010 **Start Qty: 20.00 Cust Item ID:** Req'd Qty: 20.00 **Required Date: 12/16/2010 Customer:** Reference: Start Run Date: 1012-8 Tooling: **Process Plan:** Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID **Description Run Hours** Qty Code Qty Number Stamp **Draw Nbr Revision Nbr** D3286 Rev A 100 0.00 FLOW WATER JET B 10-17-9 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3286 Dwg Rev: A 304.175 Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1B 10-12-9 QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check courtes 0.00 Sister 8 Memo Quality Control

DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr Occ Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC Corrective Action Section B		1									
Part No:PAR #:Fault Category:NCR: Yes No DQA:Date: Resolution:Disposition:QA: N/C Closed:Date: NCR:NCR: Yes No DQA:Date: Resolution:Disposition:QA: N/C Closed:Date: NCR:NCR:	W/O:			N	ORK ORDER C	HANGES					
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Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC Section A Approval Initial Action Description Sign & Section C Chief Eng Content of Note of the Content of Note of Note of the Content of Note of No											
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DATE STEP Description of NC Initial Action Description Sign & Verification Approval A Section C Chief Eng. Qu	NCR:		1	WORK OR	DER NON-CON	FORMANC	E (NCR	l)			
Section A minute Action Section C Grief Eng Qu	DATE	STEP	Description of NC	Description of NC			Sign 9				Approval
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Work Order ID 64563

Wednesday, December 08, 2010 10:26:43 A



Page 2

Item ID:

D3286-1

Accept

Setup Start

Revision ID: Item Name:

Doubler

Start Date: 12/8/2010 **Start Qty: 20.00**

Required Date: 12/16/2010

QC:

Req'd Qty: 20.00



Date:

Cust Item ID:

Customer:

Tool ID

Reference:

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Process Plan: _____

Date:

Tooling:

SPC (Y/N):

Date:

Tool # Plan

Code

Date:_

Run

Reject

Qty

Start

Stop

Stop



Number Stamp

Insp.

Reject

Sequence ID/ Work Center ID

130



Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

Form as per Dwg D3286

Set Up/ Run Hours

0.00

0.00

SB 11/03/09

Accept

Qty

20

it.

140



Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Identify as per dwg & Stock Location:

0.00

Packaging

150

Memo

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

Dart A	Aeros	pace	Ltd
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W/O:			WC	ORK ORDER CHANG	ES				,
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	-								
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
	R	lesolution:	Dispositio	n:	_ QA: N/C (Closed:		Date: _	
NCR:		1	WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	CTED	Description of NC Corrective Action			verification			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector

Work Order ID 64563

Wednesday, December 08, 2010 10:26:43 A



Page 3

Item ID:

D3286-1

Accept

Setup Start



Revision ID:

Item Name:

Doubler

Start Date:

12/8/2010

Start Qty: 20.00

Req'd Qty: 20.00



Cust Item ID:

Customer:

Tool ID

Reference:

A	nn	rov	als:	
7.8	սս	101	a13.	

Required Date: 12/16/2010

Process Plan:

QC: ____

Operation

Description

Date:

Date:

SPC (Y/N):

Set Up/

Tooling:

Date:

Date:

Run

Start

Stop



Stop

Sequence ID/

Work Center ID

160

Memo

QC21- Final Inspection - Work Order Release

Run Hours

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Quality Control

0.00

W/O:			WO	RK ORDER CHANC	GES				, E
DATE	STEP	PRO	OCEDURE CHAN		Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	Date: _	
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NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCI	3)			
	T	Description of NC Corrective Act		Corrective Action Sec	ver			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
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Picklist Print

Wednesday, December 08, 2010 10:26:47 AM

Work Order ID: 64563

Parent Item:

D3286-1

Parent Item Name: Doubler



Start Date: 12/8/2013

Required Date: 12/16/20 J

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP A□04.07.14□New issue□KJ/JLM□

IPP Rev:B Now on Waterjet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA	1 199 (8) 1 1	Purchased	No			100	sf	16.7003	0.0749	1.576842		x	
										ų	B10-17	-9	

304/316 0.125 Sheet

 Location
 Loc Oty
 Loc Code

 MAT
 16.7003

 114799
 16.7003

114799



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W/O:			WC	ORK ORDER CHANGE	S				۲
DATE	STEP	PRC	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
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NCR:			WORK ORD	ER NON-CONFORMAN	NCE (NCR)			
DATE	STEP	Description of NC			Section B Verific			Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Secti	on C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	44543
Description: Doubler	 Part Number:	D3286-1
Inspection Dwg: D3286 Rev: A	 	Page 1 of 1

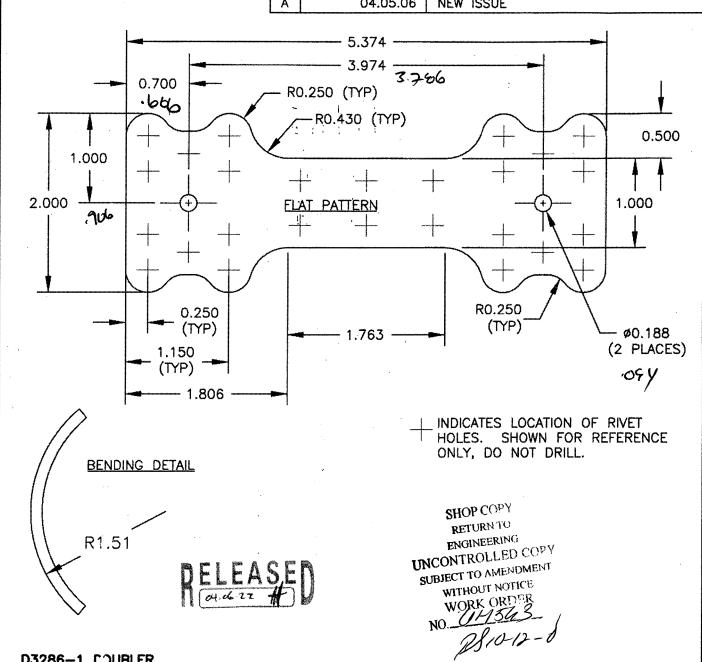
	FIRST	ARTICLE I	NSPECTI	ON CH	ECKLIST		
	X	First Art	icle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		omments
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3.974	+/-0.010	3,970	X0-		V		
2.000	+/-0.010	600.6	8		V		
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0.700	+/-0.010	706	18		٧		
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Measured by:	В	Audited by:	8		Prototype	Approval:	N/A
Date:	10-13-9	Date:	10/12/1	3		Date:	N/A
Rev Date	Change					Revised b	v Approved
A 06.11.07	New Issue					KJ/JLM 🖟	Approved E

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W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	CEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A :	Date: _	
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NCR:		\	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	CTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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DAT	E		TITLE .	SCALE
04	.05.06		GROUND HANDLING PARTS	1:1
Δ		04.05.06	NEW ISSUE	



D3286-1 COUBLER

1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK (REF DART SPEC. M304S11GA)

2) BREAK ALL SHARP EDGES 0.010 TO 0.020

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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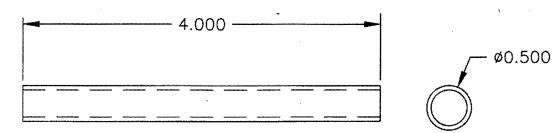
									
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DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NOTE: Date & initial all entries

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DESIGN	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V		
CHECKED,	APPROVED,	DRAWING NO.		REV.	A
4-	*#	D3286		SHEET 2 OF	2
DATE	1	TITLE		SCA	LE
04.05.06		GROUND I	HANDLING PARTS	. 1	1:1



w/0 64563

D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL (REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Categ	jory:	NC	R: Yes	No DQ	A :	_ Date: _	
Resolution:			Disposition: Q			A: N/C Closed: Date:				
NCR:		,	WORK ORDE	R NON-CONFO	RMANCE	E (NCF	3)			
DATE		Description of NC	Corrective Action Section B			Verification			Approval	Approval
		Section A	Initial Chief Eng	Action Descript Chief Eng	tion	Sign 8 Date		on C	Chief Eng	QC Inspector
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